

5/23

SPLIT

DART AEROSPACE LTD

Work Order:

23427

Description: ~~Lug~~ Clamp *EC 01-07-01*

Part Number:

D3041-1

Drawing: D3041 Rev. A

Qty:

25 4

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	<i>JA</i>	05.05.26	25
2	METAL	Cut blanks: 1.250 long Material: D2423 Lug extrusion			
3	HAAS	Machine per folio FA153 <i>Issue to 20081004</i> Check for crack while loading into the machine	<i>SD</i>	05.05.26	25
4	QC	Inspect Level 2 <i>Receive & Inspect for transit damage</i>	<i>LC</i>	05.05.26	25
5	QC	Inspect Level 3	<i>CD</i>	05/06/07	26
6	METAL	Tumble and deburr rough edges after tumbling <i>N/A</i>	<i>ML</i>	05.06.07	26
7	METAL	Acid etch and Alodine per QSI 005 4.1	<i>ML</i>	05.06.07	26
8	METAL	Inspect Level 5	<i>ML</i>	05.06.07	26
9	FINISHING	Mask inside of 0.8120" dia. Hole	<i>MM</i>	05.06.07	26
10	FINISHING	Powder Coat White (ref. 4.3.5.1) per QSI 005 4.3	<i>MM</i>	05.06.07	26
11	QC	Pick: Qty Part number Description batch 1 D2611 Bearing <i>B15 586</i>	<i>SB</i>	05/06/07	4
12	QC	Press D2611 bearing into lug as per dwg D3041	<i>SB</i>	05/06/07	4
13	QC	Stake bearing into place as per dwg D3041	<i>SB</i>	05/06/07	4
14	QC	Inspect Level 7	<i>2</i>	05-06-07	4
15	STORES	Identify and stock	<i>4</i>	05.06.07	4
16	EXPEDITING	Close W/O <i>47.42</i> Job Cost / Part <i>32095</i>	<i>JA</i>	05/06/07	4

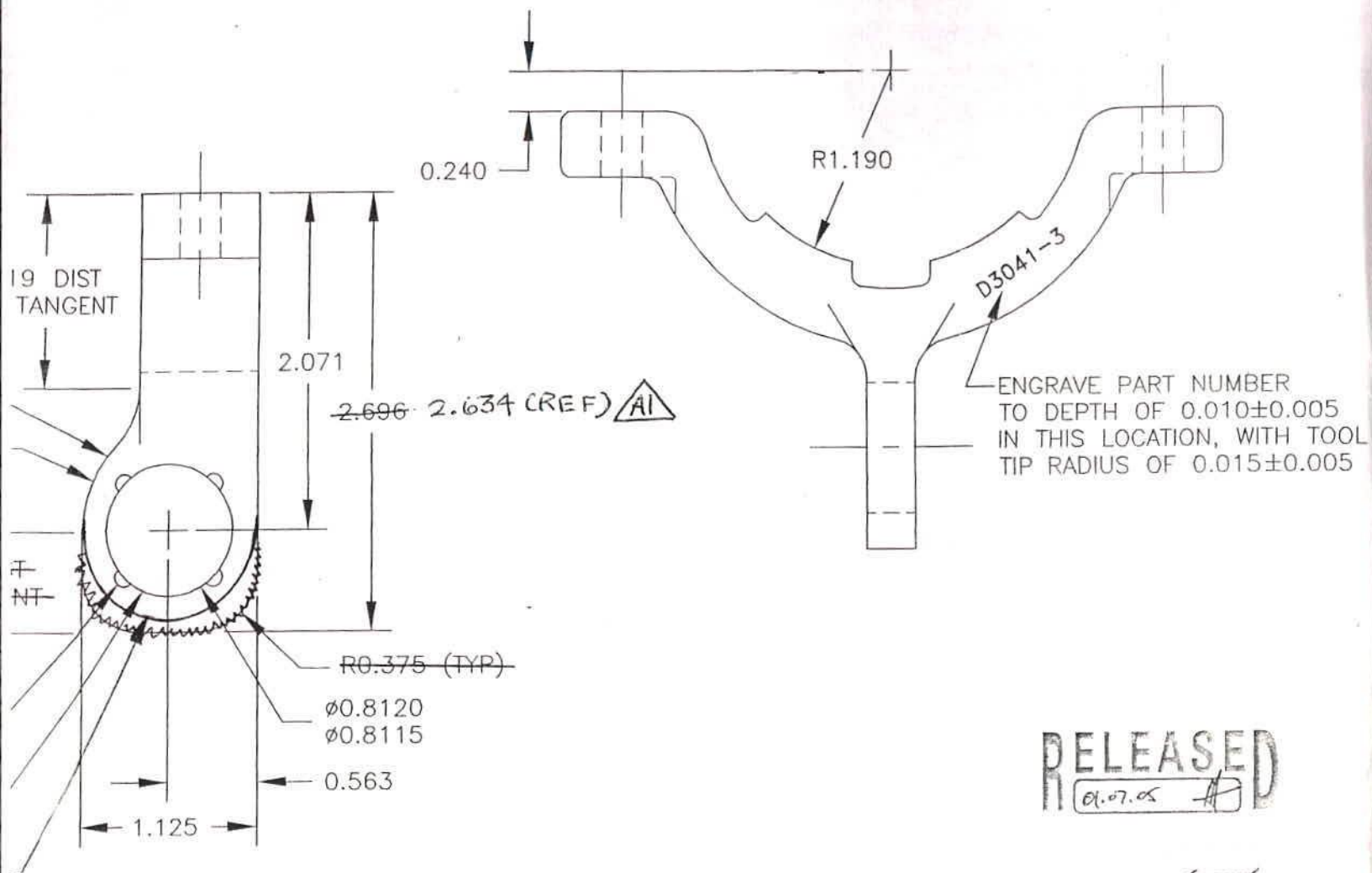
Rev	Date	Change	Revised By	Approved
A	01.07.11	New Issue	SM	<i>EC</i>

RELEASED

EC 01.07.11

D3041-3

SAME AS D3041-1 EXCEPT AS SHOWN



RELEASED
01.07.05

UNDER REVIEW
01.07.11

D3041-1 & D3041-3 CLAMPS

- 1) MANUFACTURE FROM EXTRUSION D2423
- 2) PART IS SYMMETRIC ABOUT CENTERLINE
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 5) STAKE D2611 BEARING AFTER POWDER COAT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

23427



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	DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
	CHECKED	APPROVED	DRAWING NO. D3041
	DATE	TITLE	CLAMP

REV. 1 OF 1

SHEET 1 OF 1

SCALE

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